

Date: Wednesday, 15/04/2009 2:38:57 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLIP
Job Number	: 47225		
Estimate Number	: 13861		
P.O. Number	:	Part Number	: D39301
This Issue	: 15/04/2009 S.O. No. :	Drawing Number	: D3930 PROTO <i>09.04.21 RU</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: PROTO
Previous Run	:	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 17/04/2009 Qty: 6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:A 09-04-15 new issue DD verified by:EC		

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.0400 sf(s)/Unit Total : 0.2400 sf(s)
 304/316 .040 Sheet
 Batch: *M109088*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3930
 Dwg Rev: _____
 Prog.Rev: _____

Parts were made by hand

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1- Bend as per dwg D3930

SB 09/04/16

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D206-781 / D407-781

Job #: 00276

Date: 09.04.15

Product Name: Interior Protector

Requested By: PH

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
6	D3930-1		Clip	09.04.15	Y	ASAP	Need for testing	
6	D3931-041		Clip Assembly	09.04.15	Y	ASAP	Includes D3931-1 Clip and D3802-1-010 Window Seal	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

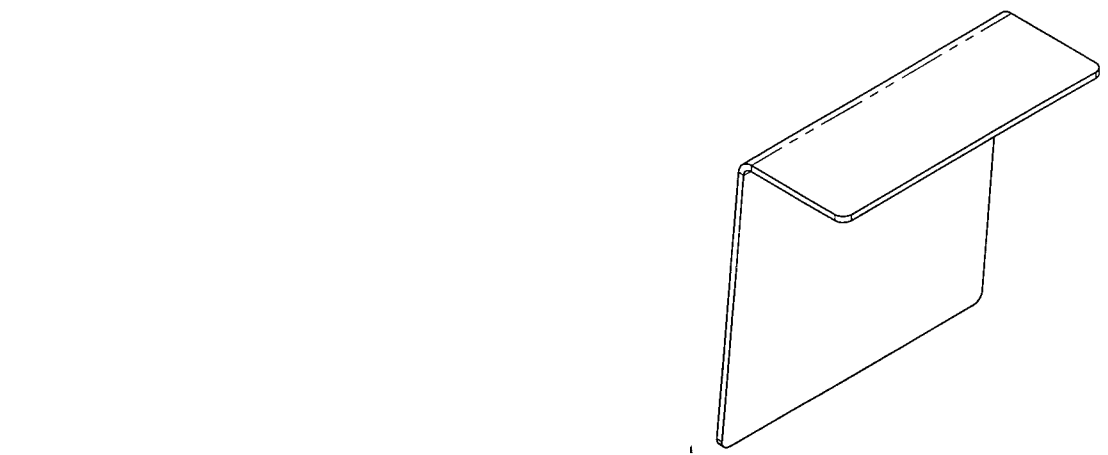
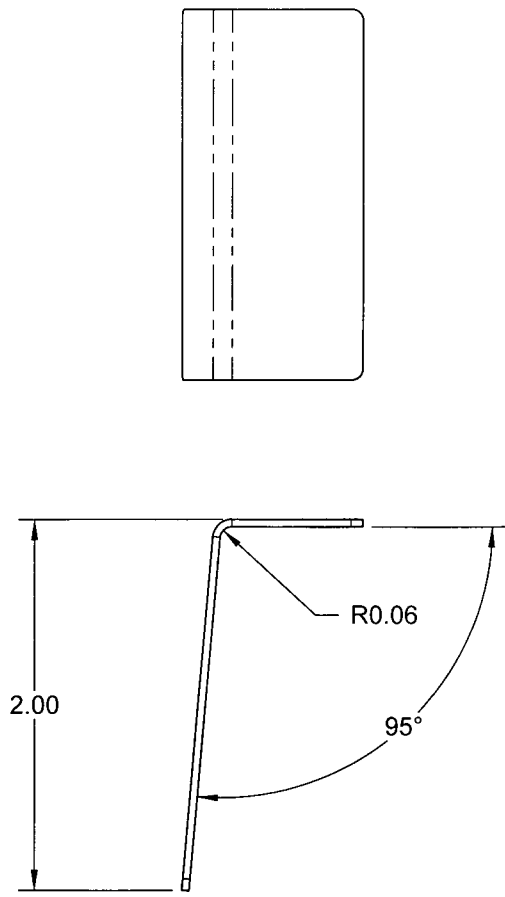
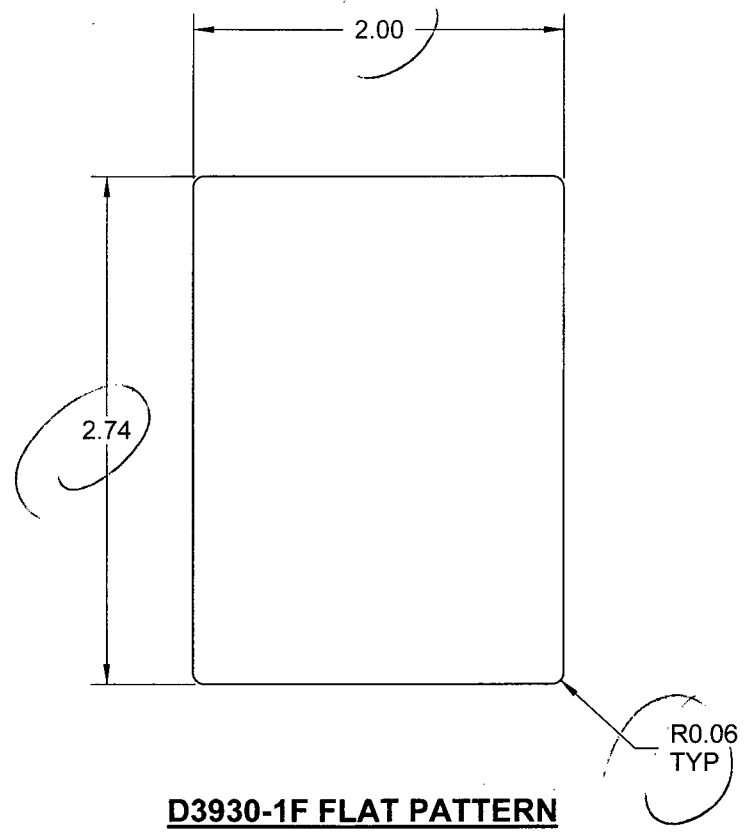
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B

B

A

A



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3930-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.04.15 *PH*
ELN 09.04.15
SUPERSEDED
ON 09.04.21 *PH*

A	NEW ISSUE	PH	09.04.06
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3930	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CLIP	NTS
DATE	09.04.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date: 8/25
Supplier: MAGNA

Batch No: M109088
Part P/O: 7044

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☒ No ☐ N/A ☐
QC6 Inspection 8/25/02 ☒ N/A ☐
Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:
Date: 8/29/02
Received/Costing: RC 8774
Initial:

Location

FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED SEP 08 2008

Sub-Total
G.S.T.

1405.00
70.25

TOTAL →

1475.25

LES D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
NT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
MINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

DART

Purchase Order

Date Aug 28, 2008	Page 1
Purchase Order Number PO00007044	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
6/28/08

Vendor Address:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada
Phone (800) 363-6646
Fax (514) 631-0013

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Aug 28, 2008	N30	yours	Aug 29, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 320.0000	M304S20GA	304/316 .040 Sheet Comments: MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH	8/29/2008	No	4.062500	sf	1,300.00
✓ 20.0000	M6061T6TR40X20W •125	6061-T6 Rect Tube 4.0 x 28/29/2008 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 RECTANGULAR TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128, 4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	28/29/2008	No	4.000000	f	80.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Comments:

Tax Summary:
GST
ONTPST

69.00
0.00

Less:
included tax

0.00

Subtotal

1,380.00

Total tax

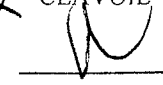
69.00

Total purchase order in

CAD Dollars

1,449.00

Entered By: CL CLAVOIE

Approved By: 



MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDE
SALES ORDER

0174638

DU À /
TO: LIVRÉ À /
SHIP TO:

ART AEROSPACE LTD
270 ABERDEEN STREET
AWKESBURY
NTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACHAT DU CLIENT CUSTOMER PURCHASE ORDER		N° DE TÉLÉPHONE DU CLIENT CUSTOMER TELEPHONE NUMBER		N° DE TÉLÉCOPIEUR DU CLIENT CUSTOMER FAX NO.					
0174638		DART		7044		613 632-5200		632-1053					
LIVRÉ VIA - SHIP VIA		CONDITIONS - TERMS		DATE COMMANDÉE DATE ORDERED		DATE REQUISE DATE REQUIRED		DATE LIVRÉE DATE DELIVERED		N° DU VENDEUR SALES REP NO.			
NIR:R-557065-1		NET 30		Aug-28-08		Aug-29-08				15 26 EB			
CONTRÔLE DE QUALITÉ DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D				CONTRÔLE DE QUALITÉ DE MAGNA REQUIS MAGNA QUALITY RELEASE REQ'D				PRÉPAYÉ PREPAID		À PERCEVOIR COLLECT			
QUALITÉ - QUALITY		UNITÉ UNIT		N° DE COULÉE HEAT NUMBER		DESCRIPTION		QTE LIVRÉE QTY SHIPPED		PRIX PAR PRICE PER		INSTRUCTIONS DE L'USINE PLANT INSTRUCTIONS	
COMMANDE ORDERED		A VENIR - B/O											
10		pcs		7044		304-2B SHEET 20GA 48 X 96		104		✓		10 pcs	
1		pcs		7044		6061-T6 ALUM 2 X 4 X .120"SQC"		3/4		✓		1 pcs	
1.00		Lot				Fuel Surcharge							
						POSITIVE RECALL							
						EFFECTIVE 8/27/04 AUTH							
						RELEASED 08/02/02 DATE							
						TOTAL :						537 LBS	

IBRE DE PAQ.
IBER OF BOL'S MTR-AVEC COMMANDE
MTR'S WITH ORDER POSTE
MAIL TÉLÉCOPIEUR
FAX

ge: 1
15:18:00 20080828

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

PACKING SLIP / BÓN D'EMBALLAGE

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

M109082

CI 488



证书编号: (2008) 证字第 (2213) 号

产品质量证明书

PRODUCT INSPECTION CERTIFICATE

ZPSS

张家港浦项不锈钢有限公司

ZHANGJIAGANG FOSHENG STAINLESS STEEL CO., LTD.

地址: 中国江苏省张家港市杨舍镇江开发区

ADDRESS: Jiang Riverside Development Zone Zhangjiagang

City Jiangsu Province China

电话 (Tel): 86-512-58333660 传真 (Fax): 86-512-58334277

邮政编码 (P.C.): 215623

合同号码: -

Contract No.

订货方: POSCO ASIA CO., LTD

品名: COLD ROLLED STAINLESS

牌号: A5DE04

证明书编号: 200806089

Order LTD

Commodity STEEL IN COIL

Type

Certificate No.

使用厂家: MAGANA

标准: ASTM A240/430

表面加工: NO. 2B

发行日期: 2008-04-29

Customer

Specification

Surface Finish

Date

序号 No	产品号码 Product No	炉号 Heat No	产品尺寸 Product Size			张数 Number	重量 Weight Kg	拉伸试验 Tensile Test			表面 硬度 Hard ness Hv	弯曲 试验 Bend ing 180°	化学成分 Chemical Composition (%)										
			厚度 Thickness mm	宽度 Width mm	长度 Length mm			屈服强度 0.2% YS N/mm ²	抗拉强度 TS N/mm ²	延伸率 EL %			C	Si	Mn	P	S	NI	Cr	N	Mo	Cu	
1	LCD0631	SF08323	1.0	1219	C	0	5219 g	255 下	670 g	58 白	162		≤0.08 0.049	≤1.00 0.49	≤2.00 1.08	≤0.04 0.032	≤0.03 0.005	2.00- 10.50 8.03	18.00- 20.00 18.17			0.18	0.10

FAX

Mr. Ashley Dion
614-621-0013
Yoon Kany (Daewoo)
Tel-264-2777
DATE 05/22/00

备注 (Remarks)

FAX

Mr. Ashley Dren
514-631-0013
Yoon Kany (Daewoo)
905-240-2739
DATE 05/20/08

备注 (Remarks):

1. 尺寸和表面: 合格

Size and Surface: Guaranteed

2. 拉伸试验: 方法符合JIS Z 2241标准; 试样规格为JIS Z 2201 5号

Tensile Test: Technique accord with JIS Z 2241;

Sample Specification accord with No.5 of JIS Z 2201

3. 硬度试验: 方法符合JIS Z 2244 标准

Hardness Test: Technique accord with JIS Z 2244

兹证明所列产品均符合订单和标准的所有要求

WE HEREBY CERTIFY THAT THE MATERIAL
HEREIN HAS BEEN MADE IN ACCORDANCE
WITH THE ORDER AND SPECIFICATION

*此报告仅可完全复制

*The report can only be copied completely

技术部

TECHNICAL DEPT.

ZHANGJIAGANG FOSHENG STAINLESS STEEL CO., LTD.

Z. D. KANG
Manager of Quality Team

002/003

DAS - LINDA

DART HELICOPTER SERVICES

FAX 613 632 4443

FRI 14:34

FAX 5146312202

FRI 14:13

Magna Stainless

8 7 6 5 4 3 2 1

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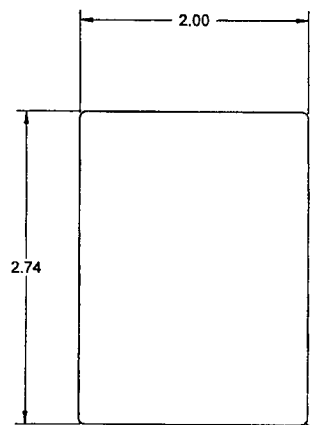
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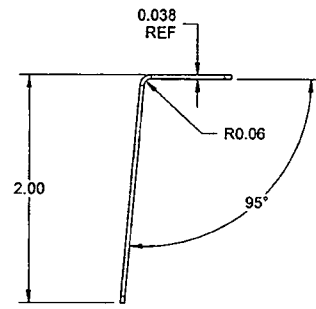
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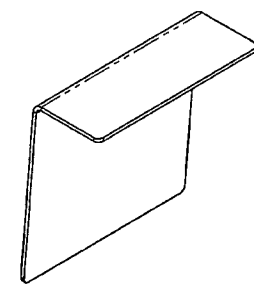
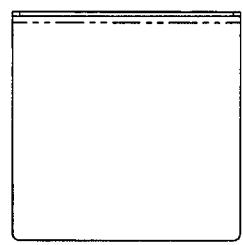
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D3930-1F FLAT PATTERN ①



D3930-1 CLIP
(MAKE FROM D3930-1F)



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3930-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

U/b 47225
Prototype 09.04.06

A		NEW ISSUE		PH	09.04.06
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	PH				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D3930	SHEET 1 OF 1		
APPROVED		TITLE	SCALE		
DE APPR.		CLIP	NTS		
DATE	09.04.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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